

Work Order ID 114543

Thursday, March 27, 2014 4:22:22 PM

114543

REPRINT

Page 1

Item ID: PB67-43001-27

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade Positioner

Start Date: 3/10/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/20/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: mf Date: 14-3-27 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-27	Rev C
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100		0.00							
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100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- slide -289 , -291 and -293 on -19 tube then slide it in -285 tube2- drill holes 0.159 (#21) thru -285 into -289 in (3) place and tap 10-32 UNF as per dwg 3- assemble all parts as per dwg PB67-43001

2# 14-3-28 DAS 24 9-89

110

QC5- Inspect part completeness to step on W/O

0.00

DAS 27 9-89

110

QC

Memo

0.00

Quality Control

14/3/28

2

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

14/3/31

14/3/31 2 DAS 32 9-89

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Revision ID:

Stop *NS2*

Item Name: Blade Positioner

Start Date: 3/10/2014 Start Qty: 2.00

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2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

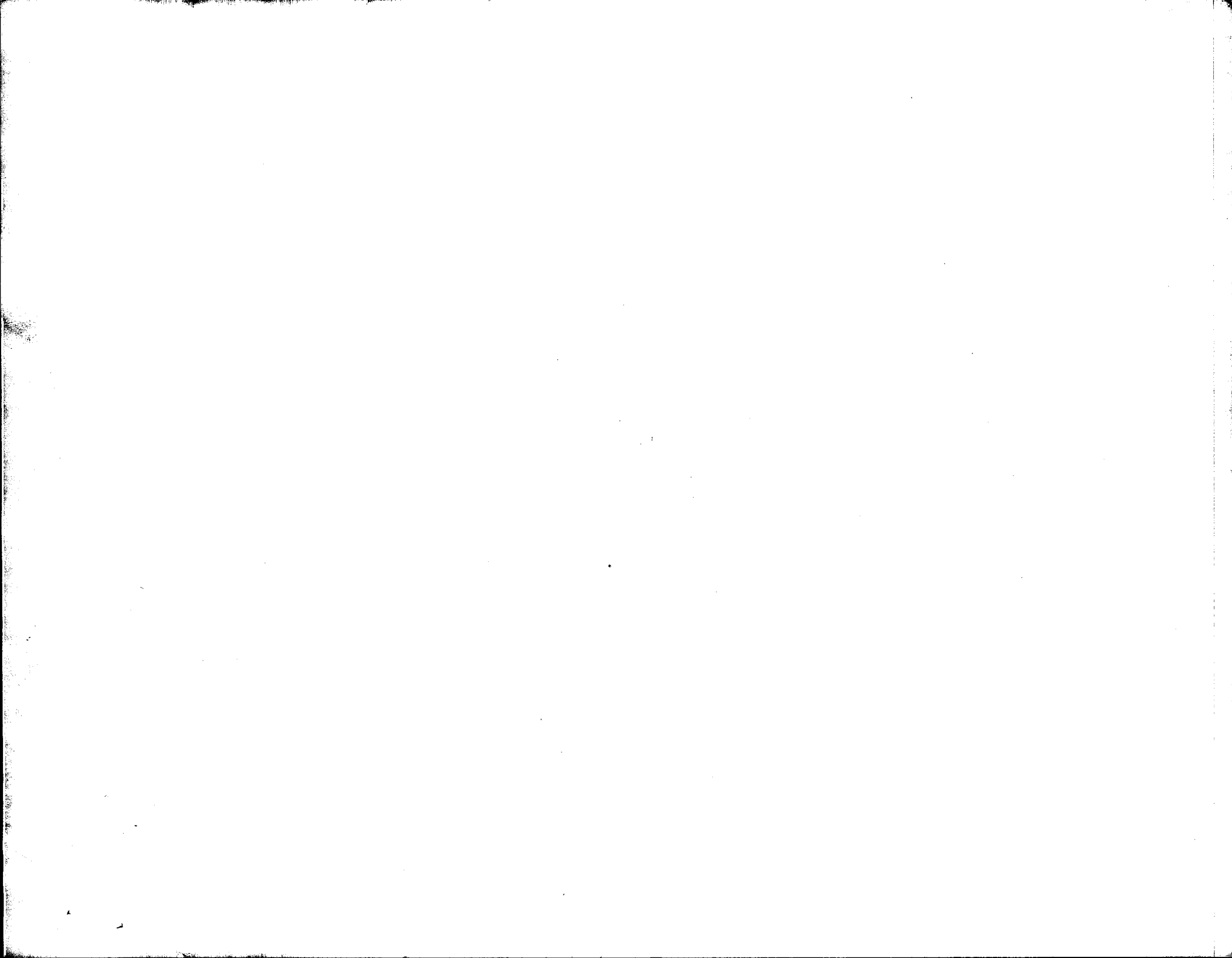
Memo

0.00

Quality Control

MLJ 14-03-31

MF
14-3-31



Picklist Print

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Work Order ID: 114543

114543

Parent Item: PB67-43001-27

PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 3/10/2014

Required Date: 3/20/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
C 10.09.28 per rev C dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-19 *PR67-43001-19* Inner Tube And Retainer Bushing		Manufactured	No			100	Each	6.0000	1	2			DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				6					
				113424				6					
PB67-43001-29 *PR67-43001-29* Blade Positioner Weldment		Manufactured	No			100	Each	6.0000	1	2			DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				6					
				113429				6					
PB67-43001-31 *PR67-43001-31* Upper Restraint Weldment		Manufactured	No			100	Each	4.0000	1	2			DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				4					
				111808				4					
PB67-43001-35 *PR67-43001-35* Lower Pad Assembly		Manufactured	No			100	Each	20.0000	1	2			DAS 24 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				20					
				100031				2					
				111762				18					

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Parent Item: PB67-43001-27

PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 3/10/2014

Required Date: 3/20/2014

Start Qty: 2.00

Required Qty: 2.00

PB67-43001-285

Manufactured

No

100

Each

6.0000

1

2

PR67-43001-285

Upper Tube, Blade Positioner

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

6

113427

6

PB67-43001-289

Manufactured

No

100

Each

10.0000

1

2

PR67-43001-289

Stationary Handle Adjustment Fitting

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

10

113428

8

99961

2

PB67-43001-291

Manufactured

No

100

Each

21.0000

1

2

PR67-43001-291

Clamp Bushing

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

21

114030

16

99960

5

PB67-43001-293

Manufactured

No

100

Each

12.0000

1

2

PR67-43001-293

Extension Tube Adjustment Fitting

DAS
24
9-89

Location

Loc Qty

Loc Code

Mezz2

12

110602

11

47365

1

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Parent Item: PB67-43001-27

PR67-43001-27

Parent Item Name: Blade Positioner

Start Date: 3/10/2014

Required Date: 3/20/2014

Start Qty: 2.00

Required Qty: 2.00
DAS
24
9-89

AN6-22A Purchased No 100 Each

31.0000 1 2

AN6-22A

BOLT

Location

Loc Qty

Loc Code

ST340

31

111060

11

M128403

20

MS21042L6 Purchased No 100 Each

597.0000 1 2

MS21042L6

Nut

Location

Loc Qty

Loc Code

ST314

597

m127304

2

m127831

26

m127904

69

m128635

500

MS27039-1-04 Purchased No 100 Each

196.0000 3 6

MS27039-1-04

Screw

Location

Loc Qty

Loc Code

ST305

196

124555

186

m128228

10

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Parent Item: PB67-43001-27

PB67-43001-27

Parent Item Name: Blade Positioner

Start Date: 3/10/2014

Required Date: 3/20/2014

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-08

Purchased

No

100

Each

2,364.000

1

2

MS27039-1-08

Screw

Location

Loc Qty

GA	19
m125654	19
ST305	2100
m128636	2100
st507	245
m127255	245

Loc Code

★★

DAS
24
9-89

MS27039-1-09

Purchased

No

100

Each

707.0000

6

12

MS27039-1-09

Screw

Location

Loc Qty

FP001	46
18057	46
GA	92
111650	92
ST305	551
122814	1
124859	150
125646	200
125654	200
ST508	18
124093	18

Loc Code

★★

DAS
24
9-89

MS51859-8

Purchased

No

100

Each

162.0000

2

4

MS51859-8

Washer

Location

Loc Qty

ST290	162
m127993	162

Loc Code

★★

DAS
24
9-89

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Work Order ID: 114543

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Parent Item: PB67-43001-27

PR67-43001-27

Parent Item Name: Blade Positioner

Start Date: 3/10/2014

Required Date: 3/20/2014

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0316P Purchased No 100 Each

100.0000 7 14

NAS1149F0316P

WASHER

DAS
24
9-89

Location

Loc Qty

Loc Code

ST295

100

113644

100

14x

NAS1149F0363P Purchased No 100 Each

774.0000 3 6

NAS1149F0363P

WASHER

DAS
24
9-89

Location

Loc Qty

Loc Code

ST510a

774

124555

600

125445

174

6x

NAS1149F0632P Purchased No 100 Each

201.0000 2 4

NAS1149F0632P

WASHER

DAS
24
9-89

Location

Loc Qty

Loc Code

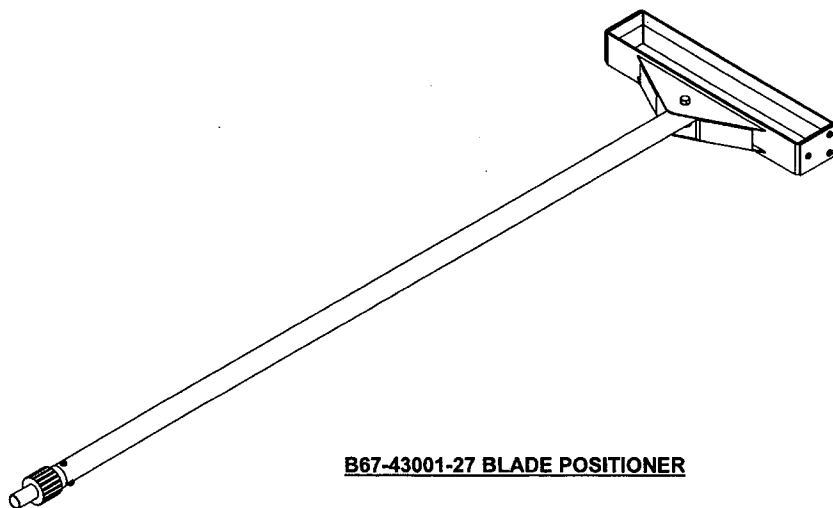
ST295

201

18057

201

4x



B67-43001-27 BLADE POSITIONER

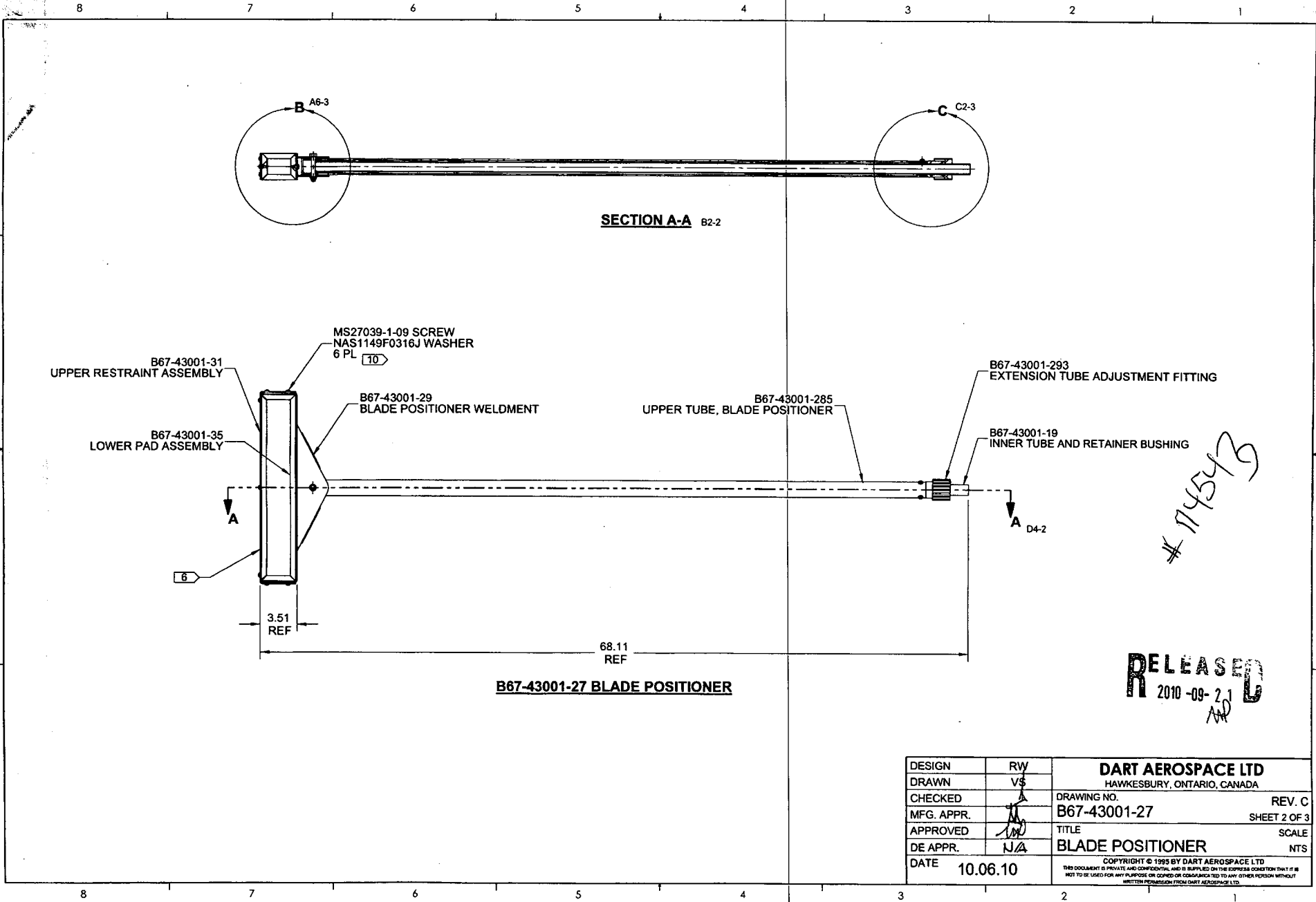
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 7.07 lbs
- 8) DRILL THRU B67-43001-285/-289 PRIOR TO ASSEMBLY
- 9) DO NOT TORQUE NUT ON BOLT: TIGHTEN UNTIL SNUG
- 10) MATCH DRILL Ø0.193 HOLE THRU B67-43001-29 WITH NUTPLATES LOCATED ON B67-43001-35

ITEM	QTY. -27	P/N	DESCRIPTION
	X	B67-43001-27	BLADE POSITIONER
1	1	B67-43001-19	INNER TUBE AND RETAINER BUSHING
2	1	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-31	UPPER RESTRAINT ASSEMBLY
4	1	B67-43001-35	LOWER PAD ASSEMBLY
5	1	B67-43001-285	UPPER TUBE, BLADE POSITIONER
6	1	B67-43001-289	STATIONARY HANDLE ADJUSTMENT FITTING
7	1	B67-43001-291	CLAMP BUSHING
8	1	B67-43001-293	EXTENSION TUBE ADJUSTMENT FITTING
9	1	AN6-22A	BOLT
10	1	MS21042L6	NUT
11	3	MS27039-1-04	SCREW
12	1	MS27039-1-08	SCREW
13	6	MS27039-1-09	SCREW
14	2	MS51859-8	WASHER
15	7	NAS1149F0316P	WASHER
16	3	NAS1149F0363P	WASHER
17	2	NAS1149F0632P	WASHER

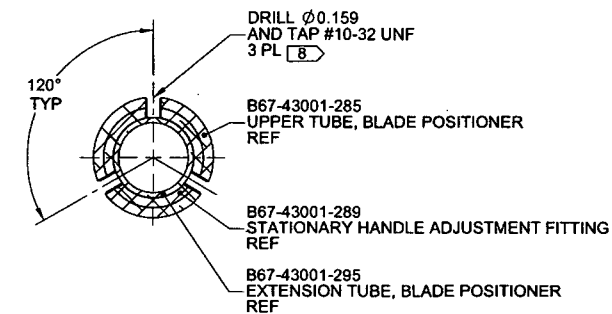
RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 4 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		VS	10.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED	VS	DRAWING NO.	REV. C	
MFG. APPR.	VS	B67-43001-27	SHEET 1 OF 3	
APPROVED	VS	TITLE	SCALE	
DE APPR.	VS	BLADE POSITIONER	NTS	
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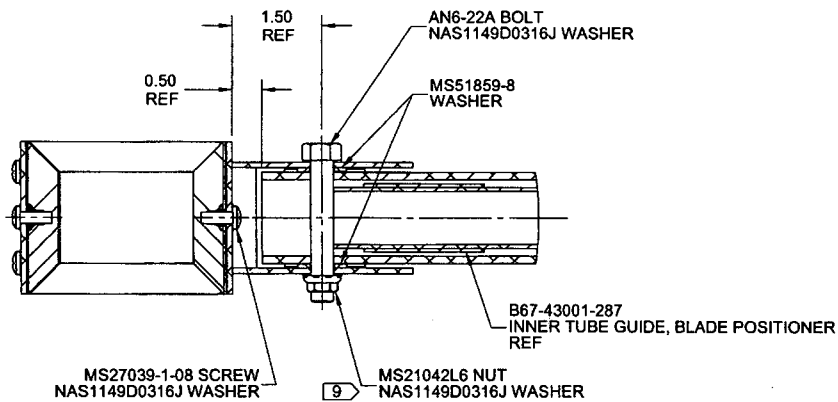


RELEASED
2010-09-23
AD

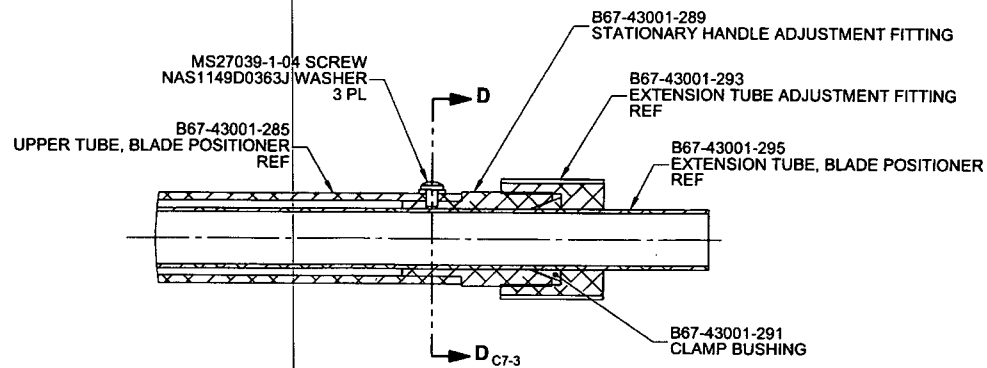
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	BLADE POSITIONER	NTS
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SECTION D-D C3-3
(HARDWARE NOT SHOWN FOR CLARITY)



DETAIL B
SCALE 4X D7-2



DETAIL C D3-2
SCALE 4X

#114543

RELEASED
2010-09-21

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	VJ	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-27	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BLADE POSITIONER	NTS
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